

Date: Thursday, 3/16/2006 10:38:25 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR ADAPTER
Job Number : 26280	
Estimate Number : 12133	
P.O. Number : N/A	Part Number : D3476043
This Issue : 3/16/2006 S.O. No. : N/A	Drawing Number : D3476 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/31/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.03.16</u>	
Comment : Est Rev:A New Issue 06-01-31 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34763	blower motor adapter
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Qty Part Number Description Batch 1 D3476-3 blower motor adapter <u>025689-1</u> <u>06.03.28</u> ①		
2.0	D34767	TUBE
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Qty Part Number Description Batch 2 D3476-7 Tube <u>B26300</u> <u>06.03.28</u> ②		
3.0	D34761	duct
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Qty Part Number Description Batch 1 D3476-1 Duct <u>B26301</u> <u>06.03.28</u> ①		
4.0	NAS1031C3W	Nutplate
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Qty Part Number Description Batch 4 NAS-1031C3W Nutplate <u>M19005 / M19051</u> <u>06.03.28</u> ④		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018 <u>06.03.28</u> ①		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: SD Date: 06/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/16/2006 10:38:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 26280

Part Number: D3476043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06.03.24

①

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: _____

Electro Chemically Polish weldment as per Dwg Dwg D3476

Ensure Certificate of Conformity is attached

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06.03.24

②

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.03.30

③

Job Completion



06.03.30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

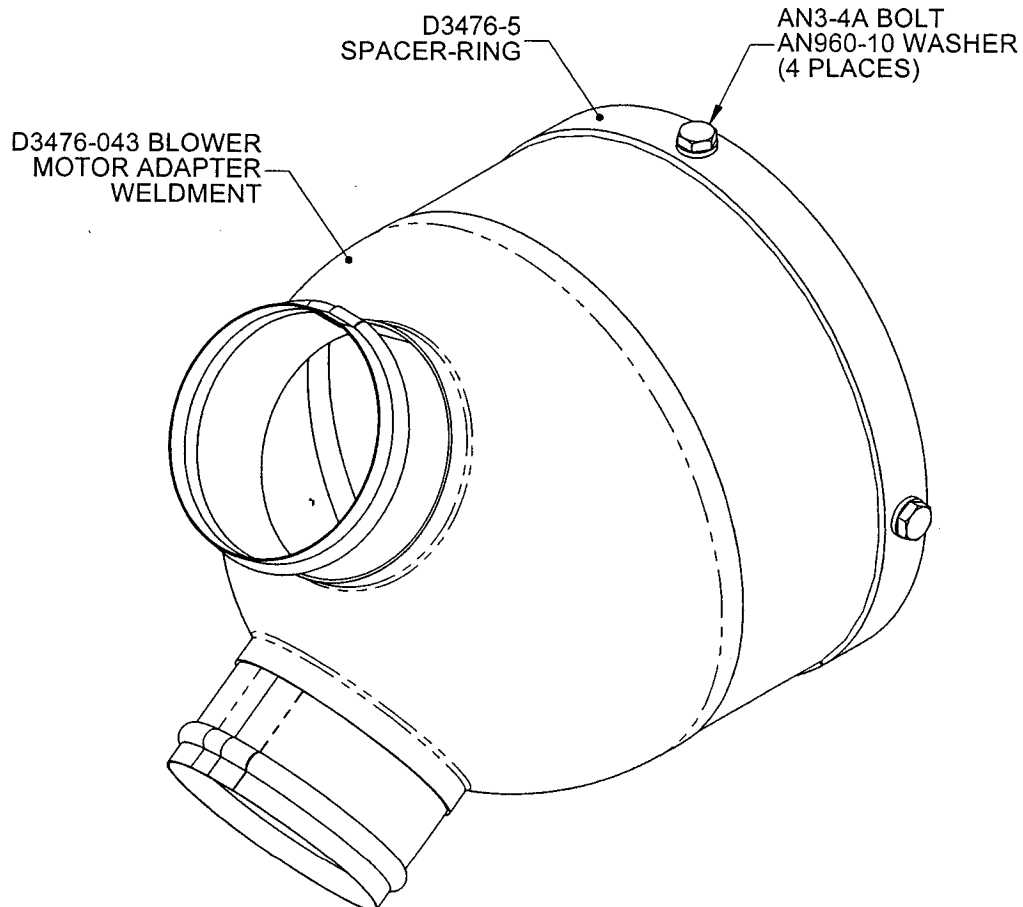
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 1 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:2	
A	06.01.27	NEW ISSUE	

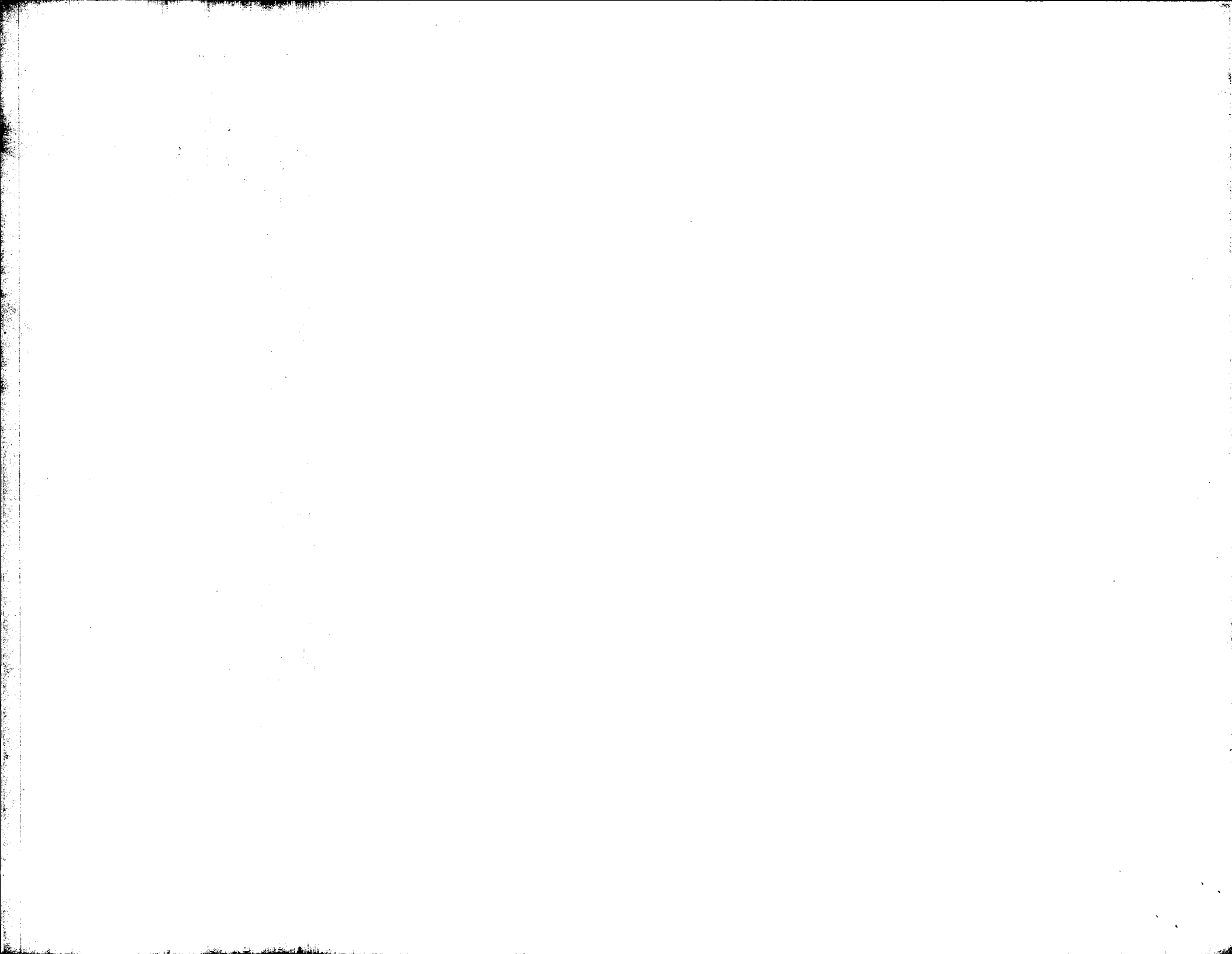


D3476-041 BLOWER MOTOR ADAPTER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26280

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

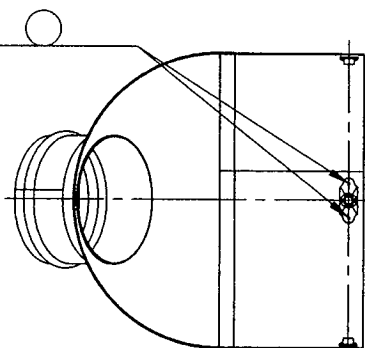
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



PRELIMINARY ISSUE

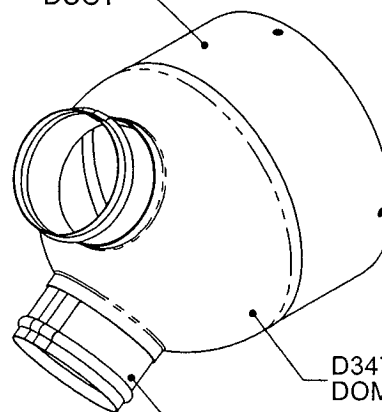
DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 2 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	
		SCALE 1:4	

LOCATE AND
SPOT WELD
NUT PLATES
(4 PLACES)



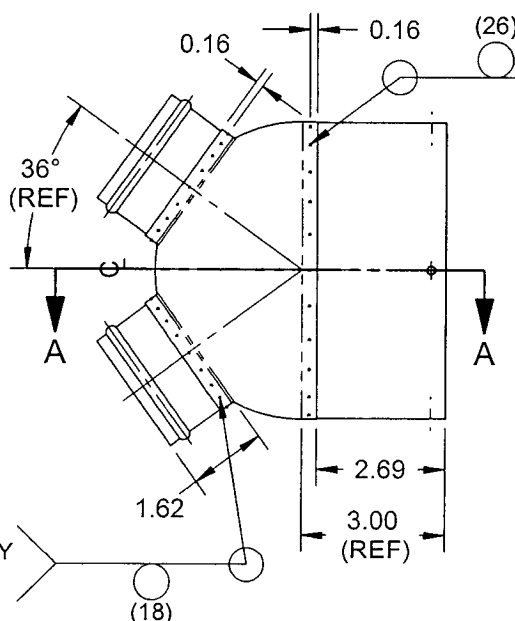
SECTION A-A

D3476-1
DUCT



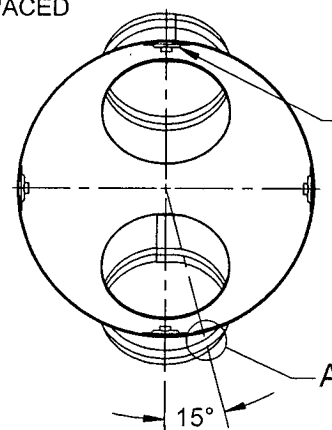
D3476-3
DOME

D3476-7 TUBE
(2 PLACES)



EQUALLY
SPACED

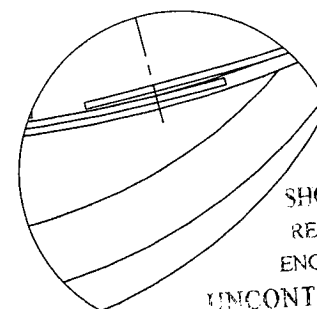
NAS-1031C3W
NUT PLATES
(4 PLACES)



D3476-043 BLOWER MOTOR ADAPTER WELDMENT

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010



SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

DETAIL A: OFFSET
SEAM ON DUCT

SCALE 2:1

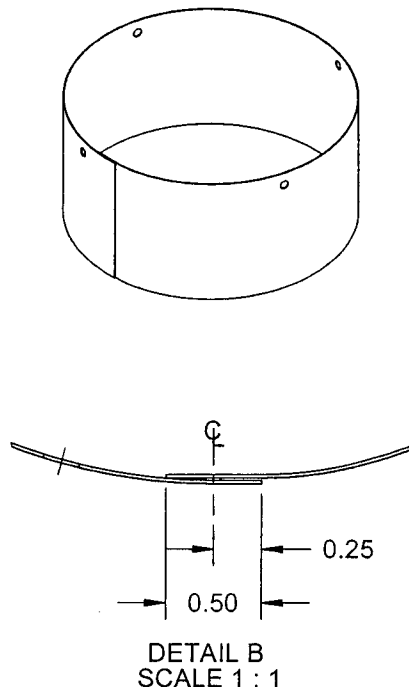
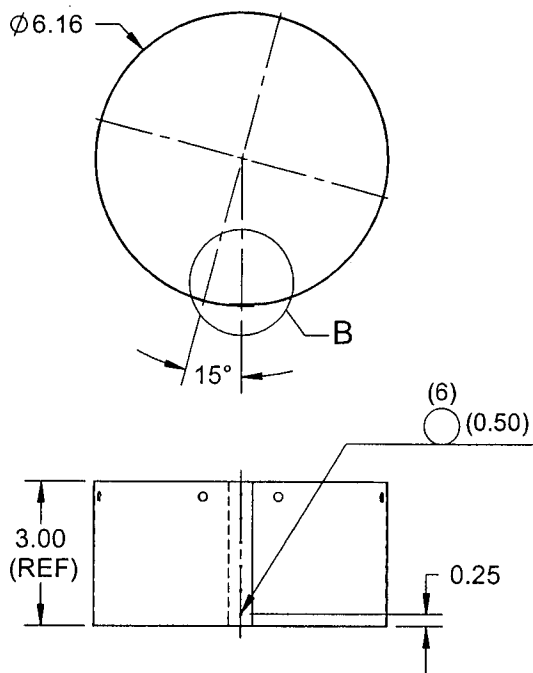
WORK ORDER
NO. 26280

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

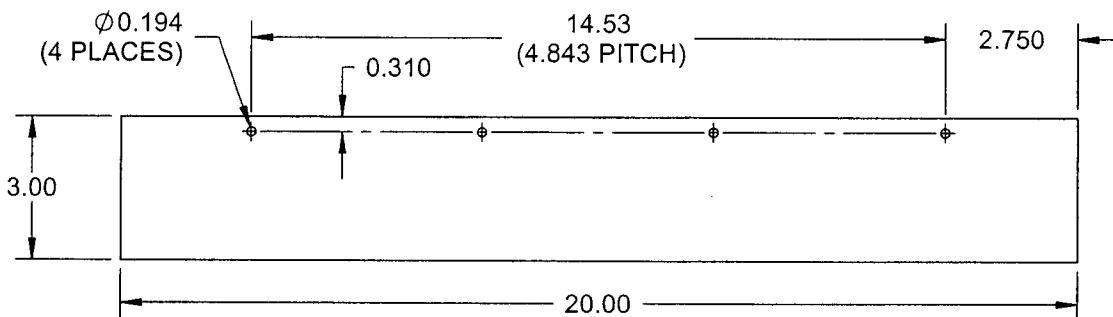
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 3 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4



D3476-1 DUCT



D3476-1F DUCT FLAT PATTERN

NOTES:



- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

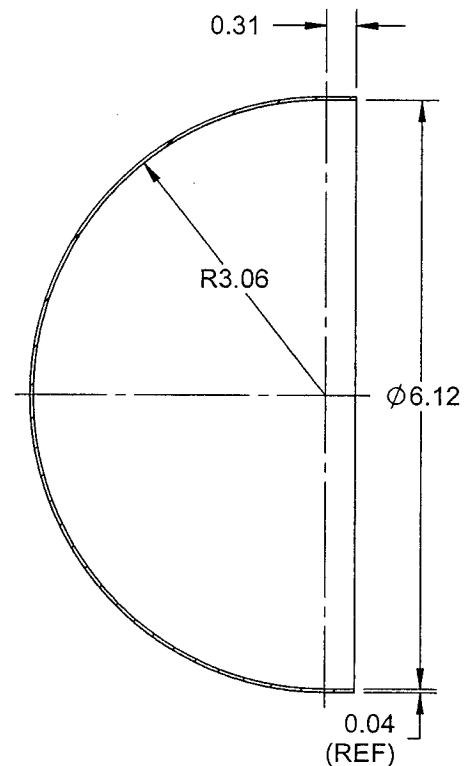
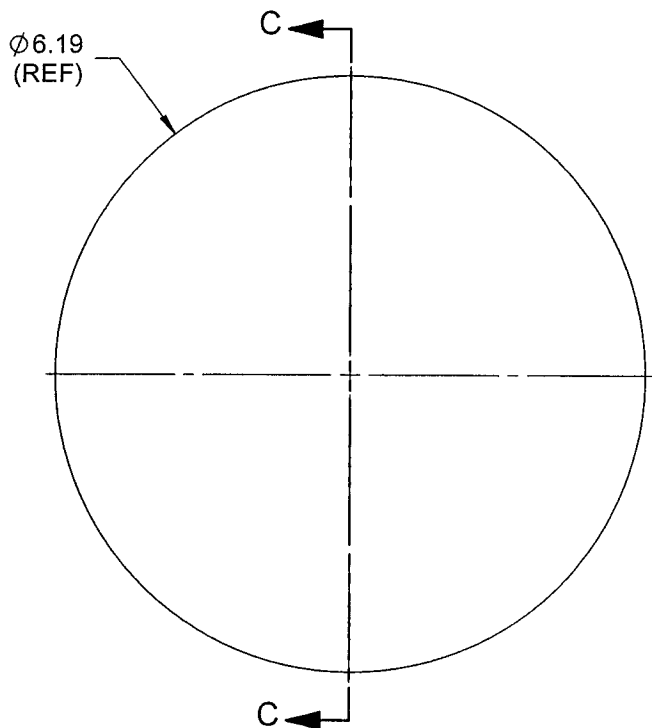
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26280

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 4 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2



SECTION C-C

D3476-3S DOME, SPINNING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING
OF MATERIAL.
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

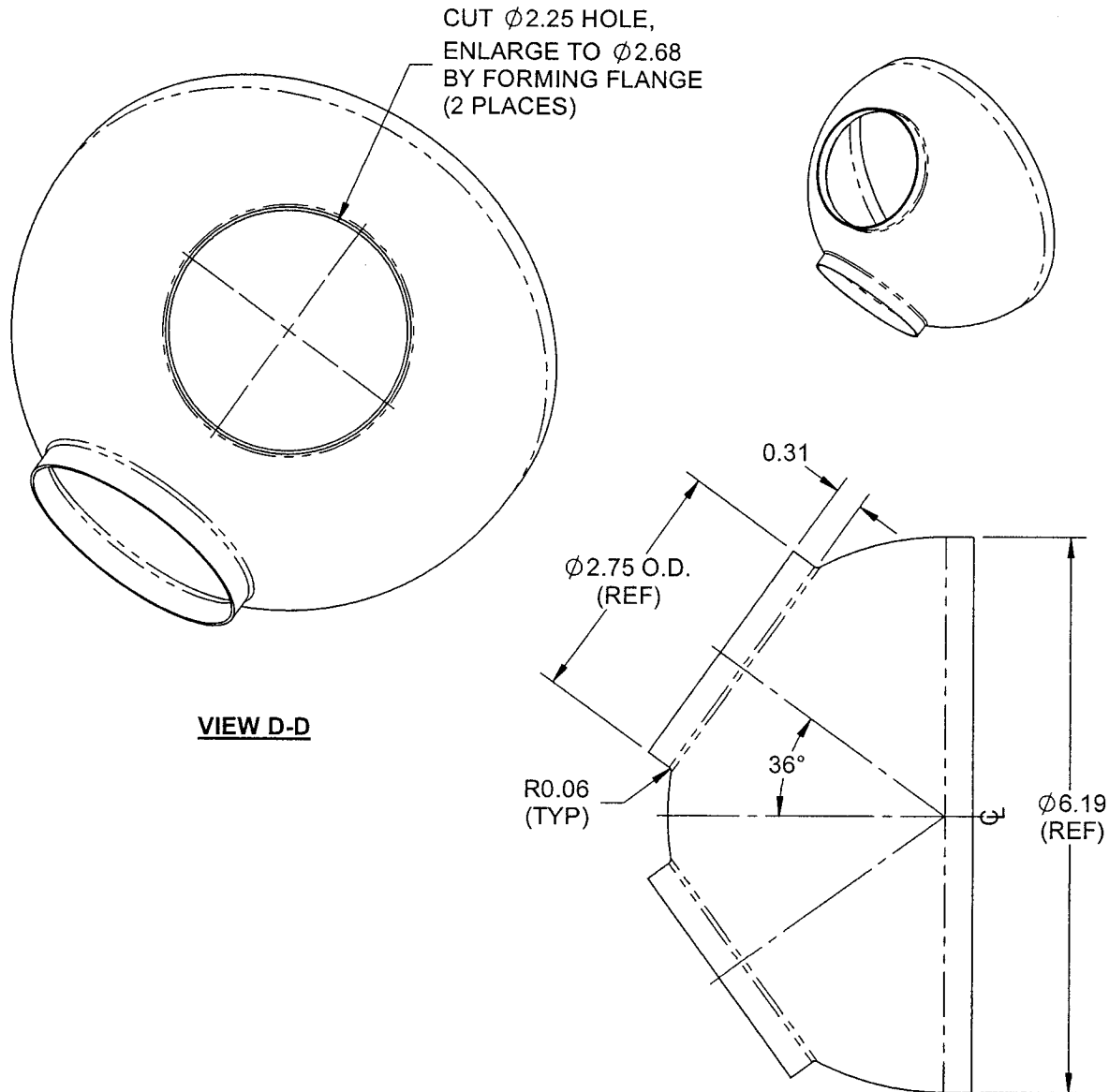
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26280

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 5 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	
		SCALE 1:2	



D3476 DOME

NOTES:

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

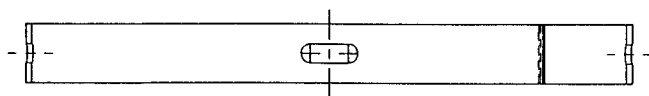
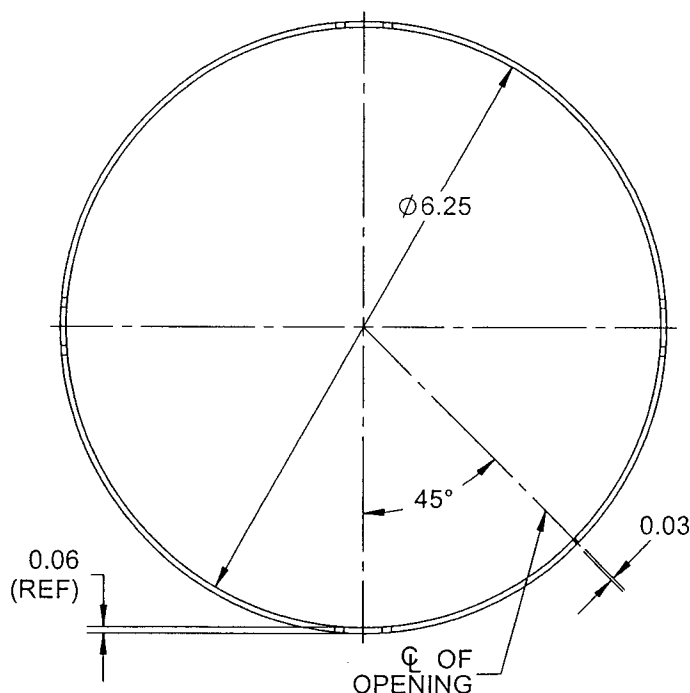
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26280

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

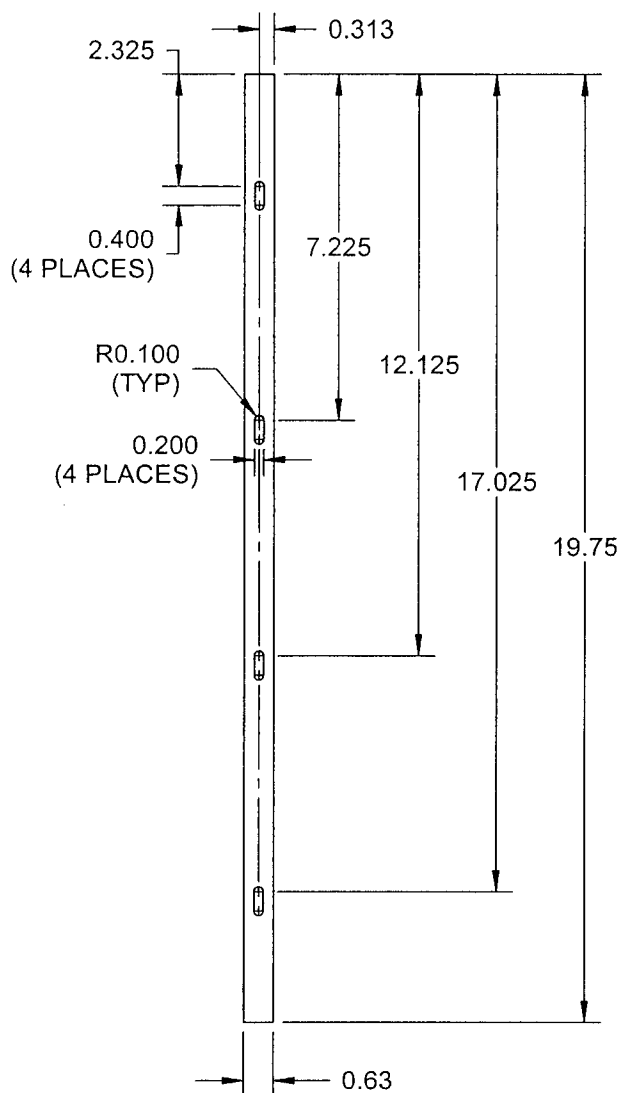
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 6 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2



D3476-5 SPACER-RING





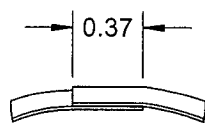
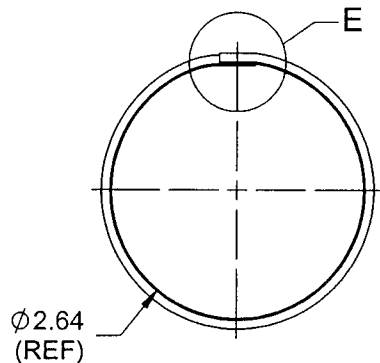
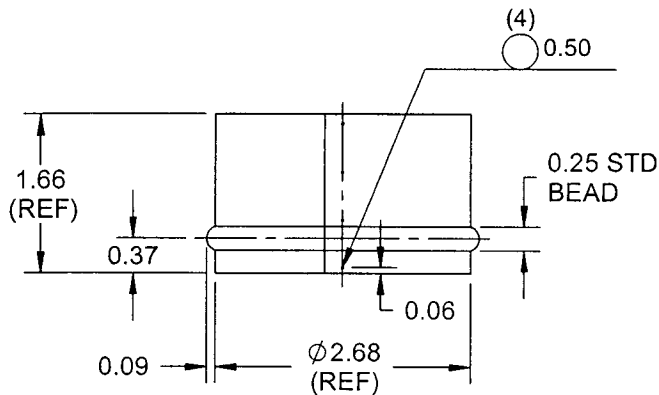
**D3476-5F SPACER-RING
FLAT PATTERN**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED)
2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

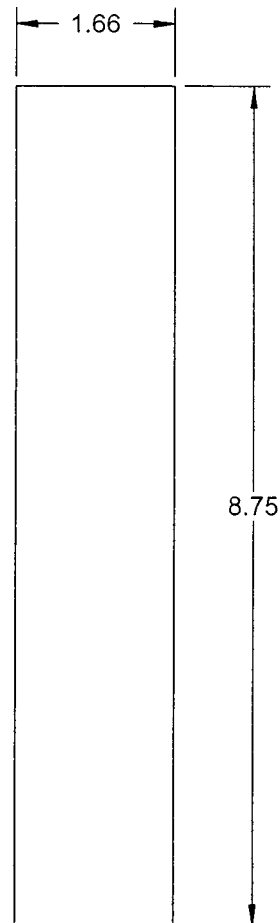
PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 7 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:2	



DETAIL E
SCALE 1 : 1

D3476-7 TUBE



**D3476-7 TUBE
FLAT PATTERN**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2628

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.